

Work Order ID 67867

Friday, April 01, 2011 1:53:10 PM



Page 1

Item ID: D212-664-101

Accept



Setup Start



Revision ID:

Item Name: Crosstube Fwd

Stop



Start Date: 4/1/2011 Start Qty: 1.00

Required Date: 4/8/2011 Req'd Qty: 1.00



Cust Item ID:

Customer:

Reference:

Approvals: Process Plan: *CL*

QC:

Date: 11/04/01

Tooling:

Date:

Date:

SPC (Y/N):

Date:

Run Start



Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D212-664-141

Rev D

100

0.00



DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy bluefile and create labels as per PPP D212-664-101

110

0.00



Pick Kit

Packaging

Packaging

Memo

0.00

Packaging

120

0.00



BENDING MACHINE - CROSSTUBES

CNC Bend 2

Memo

0.00

CNC Alpha 160 Bender

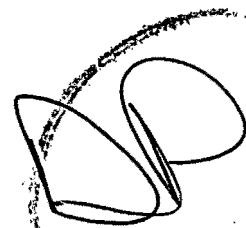
Bend tube as per Dwg D212-664-141 using CNC bender program 212-fw and Folio D212-664-101

Schulz

CHG 009

PER ECN 11-549

11-4-18



11-4-5



11-4-5

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval, Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Customer:

Reference:

Run Start



Approvals: Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

QC15- Crosstube Dimensional Check

0.00



QC

Memo

0.00

Quality Control

8.26.06

(X)

140

Crosstubes

0.00



Crosstubes

Memo

0.00

Crosstubes

1-Drill pilot holes in tube as per Dwg D212-664-141 using drill Jig DT8548 & DT8549, using drill table DT8577, set-up towers in hole #7 as per QSI 10

2-Ream hole to finish size in tube as per Dwg D212-664-141 using drill Jig DT8548 & DT8549. Check dimensions between holes, both sides on both cuffs, to ensure alignment with saddle holes.

3-Scribe part # and batch # using vibrating stylus as per Dwg D212-664-141

4-Deburr & Inspect for surface damage. Repair damage within limits as per Dwg D212-664-141

SAD 11-04-06

SAD 11-04-06

(1)

W/O:		WORK ORDER CHANGES					
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Customer:

Reference:

Run Start



Approvals: Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID Tool # Plan Code Accept Qty Reject Qty Reject Number Insp. Stamp

150

Crosstubes Chemical Conversion

0.00



HandFXtube

Memo

0.00

Hand Finishing Crosstubes

Chemical Conversion Coat within 24 hours of bending and drilling

SAN
11-04-11



160

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

Suboly

170

Outsource process - NDT per QSI038 4.1

0.00



Outsource2

Memo

0.00

Outsource process - NDT

Liquid Penetrant Inspection as per QSI 038
Issue P/O: 13857
LPI as per ASTM 1417 Level 2
Attach copy of NDT results to work order

CL 11/04/13

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval, Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Cust Item ID:

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Customer:

Reference:

Run Start



Approvals: Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

180

Receive & Inspect for Damage & Mat'l Certs

0.00



Packaging

Packaging

Memo

0.00

Packaging

Ensure copy of NDT results attached to work order.

4/4/13 (1)

190

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

Inspect for damage & ensure results are as per Dwg D212-664-141

FT 11-04-14

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
---------	--------	-----------	------------	------------	---------------	-------------

200

Spray Painting per QSI005 4.2

0.00



SprayPaint

SprayPaint

Memo

0.00

Spray Painting

1-Prime inside and outside crosstube as per QSI 005 4.2
2-Paint outside crosstube with White Imron as per QSI 005 4.2

PRIME:

Start Time:

Finish Time:

PAINT:

Start Time:

Finish Time:

210

QC14- Inspect Spray Paint

0.00



QC

Quality Control

Memo



0.00

Then, Wrap in plastic bag to protect from scratches

25 11-04-15

ml 11-04-16

Dart Aerospace Ltd

W/O: 67867		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
11-04-14	200	prime entire outside surface using tempo epoxy primer clean coat inside center strip 2" wide staying 2" away from cuff all over to dry	BT	11-04-15	1	 11.04.15	ml/ml 11/04/16	
		mask off 2" strip 2" away from cuff cuff exposed primer + paint in/on white	BT	11-04-15		 11.04.15	ml/ml 11/04/16	

Part No: D212-664-101 PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Start Date: 4/1/2011 Start Qty: 1.00

Required Date: 4/8/2011 Req'd Qty: 1.00

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

220

0.00



Crosstubes

Crosstubes

Memo

0.00

Crosstubes

1- Lightly scuff the bonded area using a 320 grit sand paper and clean the area with 41058 wash 'n' wipe
2- Install supports with magnobond as per QSI 015. Adhere for 12 Hrs
A/R 6398 Magnobond Batch: 116677
3- Torque bolts as per dwg

BT 11-04-17
(Pto)

230

QC6- Inspect dimensions to drawing

0.00



QC

Memo

0.00

Quality Control

m/l 11/04/18 (1)

240

Pick Kit

0.00



Packaging

Memo

0.00

Packaging

11/4/18 (1)

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
11-04-17	220	use MS21920-24 clamps - 25 no more stock -26 too long	BT	11-04-18	1	11-04-18 QSI 042	MW 11/04/18

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Work Order ID 67867

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Item Name: Crosstube Fwd

Start Date: 4/1/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 4/8/2011 Req'd Qty: 1.00

Customer:

Reference:

Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

250



QC

Quality Control

QC4- 100% Inspect kits for completeness

0.00

0.00

Memo

*8/10/11**2*

260



Packaging

Packaging

Packaging

Memo

Identify and pack for shipping as per PPP D212-664-101

0.00

0.00

*Leve**11/4/18*

270



QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

0.00

Memo

*11/4/18**11-04-18*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Picklist Print

Friday, April 01, 2011 1:53:07 PM

Work Order ID: 67867

Parent Item: D212-664-101

Parent Item Name: Crosstube Fwd



Start Date: 4/1/2011

Required Date: 4/8/2011

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:EI 104.02.1611 Reformat I KJ/DS
IPP Rev:F 06-03-29 Remove Coments on Pick List JLM
IPP Rev:G 07-04-30 As per Rev C JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D212-664-101 TRN

Manufactured

No

110

Each

4.0000

1

1



Crosstube Turning Detail

Location

Loc Qty

Loc Code

LG

67865

4

67218

1

67219

1

67570

1

67571

1

D3595-063-450

Manufactured

No

230

Each

79.0000

4

4.210526



RUBBER CUSHION

Location

Loc Qty

Loc Code

LG

66

67353

66

LG055

13

67067

13

MS21920-2

24 refer to step 220

Purchased

No

220

Each

68.0000

4

4



Clamp(per MIL-DTL-8783C)

Location

Loc Qty

Loc Code

LG050

68

116264

18

117279

50

① DP 11-4-5

FT 11-04-12

107441

FT 11-04-12

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Picklist Print

Friday, April 01, 2011 1:53:07 PM

Page 2

Work Order ID: 67867

Parent Item: D212-664-101

Parent Item Name: Crosstube Fwd



Start Date: 4/1/2011

Required Date: 4/8/2011

Start Qty: 1.00

Required Qty: 1.00

D2893-1

Manufactured No

220

Each

15.0000

2

2



2.75 Support

67619 x 1



AT 11-04-17

Location

Loc Qty

Loc Code

LG052

15

66698

15

D3428-1

Manufactured No

240

Each

23.0000

1

1



Placard

X 1



Location

Loc Qty

Loc Code

ST053

23

66115

11

66961

12

AN6-35A

Purchased No

240

Each

100.0000

4

4



BOLT

66115



Location

Loc Qty

Loc Code

ST343

100

113422

30

115698

20

116528

50

AN6-36A

Purchased No

240

Each

15.0000

4

4



Bolt

113422



Location

Loc Qty

Loc Code

ST343

15

117010

15

117313 11/4/18 (1)

Friday, April 01, 2011 1:53:07 PM

Shop Packet Print

Page 2

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Picklist Print

Friday, April 01, 2011 1:53:07 PM

Work Order ID: 67867

Parent Item: D212-664-101

Parent Item Name: Crosstube Fwd

Page 3



Start Date: 4/1/2011

Required Date: 4/8/2011

Start Qty: 1.00

Required Qty: 1.00

MS21042L6

Purchased

No

240

Each

138.0000

6

6



Nut



C

Location

Loc Qty

Loc Code

ST300

138

116373

38

116548

100

AN960JD616

NAS1149D0663J

Purchased

No

240

Each

0.0000

18

18



Washer



116048

11/6285

C 11/4/10 C

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

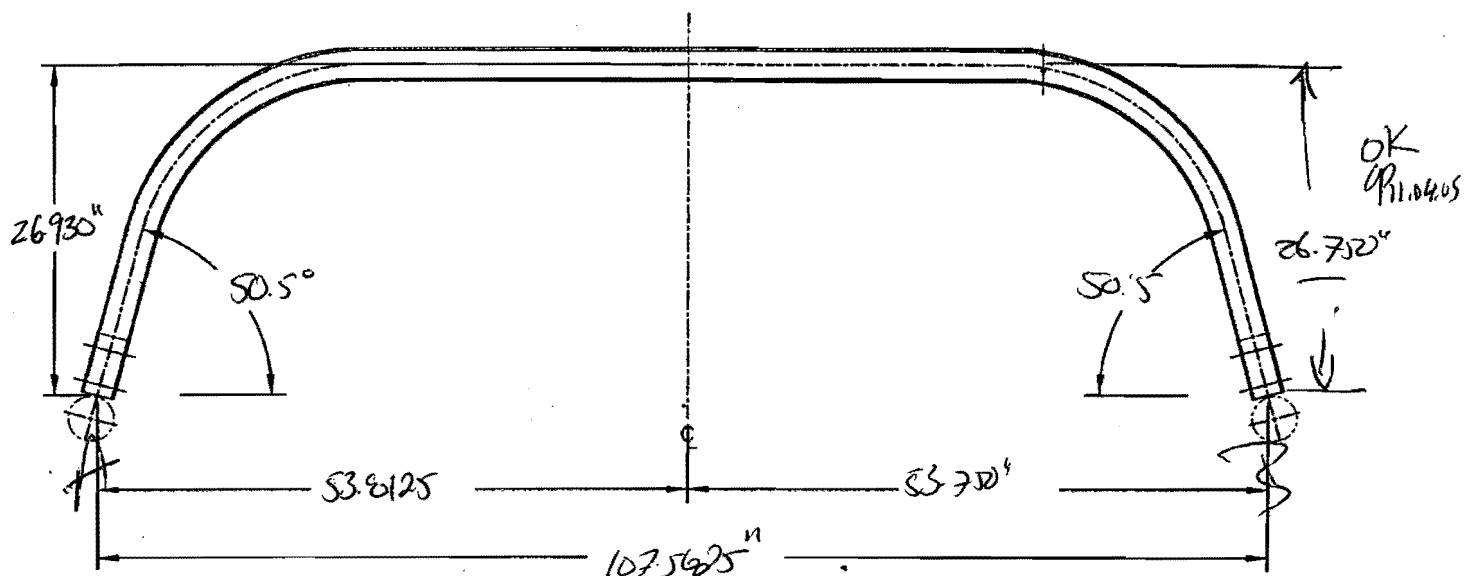
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NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	67867
Description: Crosstube High Fwd (205/212/412)		Part Number:	D212-664-101
Inspection Dwg: D212-664-141 Rev: D		Page 1 of 1	

Required Dimension	Min	Max
Height	26.79	27.05
1/2 Span	53.59	53.85
Angle	49	52
Total Span	107.18	107.7



Comments
Tube bent low on one side, Acceptable P11.04.05 (KJ/JM)

QC15 Inspection	S
Date	11/04/05

Rev	Date	Change	Revised by	Approved
A	07.02.06	New Issue	KJ/JM	
B	07.05.31	Dimensions updated per Dwg Rev C	KJ/JM	
C	10.04.01	Dwg Rev updated	KJ	

53.8125
53.7200
107.5625

8 7 6 5 4 3 2 1



Item	Qty -141	Qty -141B	Part Number	Description
1	X		D212-664-141	CROSSTUBE ASSEMBLY (205/212/412 HIGH FWD)
2		X	D212-664-141B	CROSSTUBE ASSEMBLY (214 HIGH FWD)
3	1	1	D6005-128	CROSSTUBE
4	2	2	D2893-1	SUPPORT
5	4	4	D3595-063-450	RUBBER CUSHION
6	4	4	MS21920-25	CLAMP (OR MS21920-26)
7	A/R	A/R	MAGNOBOND 6398	ROCKWELL SPECIFICATION RBO-120-023 ADHESIVE (TEXTRON/BELL SPEC. 299-947-100, TYPE II, CLASS 2 ADHESIVE)

GENERAL NOTES:

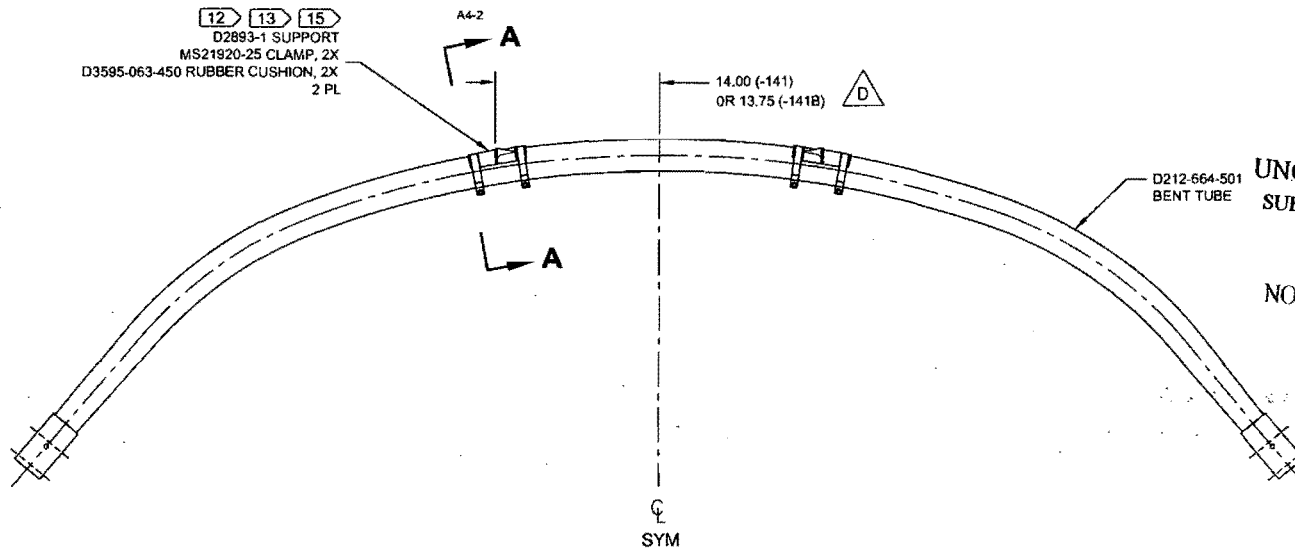
- 1) MATERIAL: MANUFACTURED FROM D6005-128
FINISHED LENGTH = 126.514±0.020
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
PRIME INSIDE AND OUTSIDE PER DART QSI 005 4.2
PAINT OUTSIDE PER DART QSI 005 4.2
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED.
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX.
- 6) IDENTIFICATION: SCRIBE DART PART NUMBER "D212-664-XXX" AND BATCH NUMBER ON INSIDE OF CUFF
USING VIBRATING STYLUS
- 7) WEIGHT: D212-664-141 = 33.6 lbs (PER IIN-D212-664)
D212-664-141B = 33.6 lbs (PER IIN-D212-664)
- 8) PART IS SYMMETRIC ABOUT CENTERLINE.
- 9) RUN CUTTER OFF PART. BLEND OUT EDGE LONGITUDINALLY. TRANSITION SHOULD BE SMOOTH.
- 10) BEND PROGRESSIVELY WITH A MINIMUM OF 3 PASSES. MAXIMUM TUBE FLATTENING DUE TO BENDING IS
6% BASED ON O.D.
- 11) LIQUID PENETRANT INSPECT OUTSIDE SURFACE OF CROSSTUBE PER QSI 038.
- 12) INSTALL D2893-1 SUPPORT USING 0.03" TO 0.06" THICK LAYER OF MAGNOBOND 6398 TO THE SURFACE OF
D2893-1 THAT WILL BE IN CONTACT WITH THE CROSSTUBE PER QSI 015. LET CURE FOR 12 HOURS AFTER
INSTALLATION AND PRIOR TO PACKAGING.
- 13) INSTALL MS21920-25 CLAMPS (OR -26) WITH D3595-063-450 RUBBER CUSHIONS TO SECURE THE D2893-1
SUPPORT ON TOP SIDE OF THE CROSSTUBE. ENSURE CLAMPS ARE OPPOSITE OF CROSSTUBE
SUPPORT.
- 14) EXTREME CARE MUST BE TAKEN TO PROTECT THE OUTSIDE SURFACE OF THE TUBE. THE OUTSIDE
SURFACE MUST BE SMOOTH AND FREE FROM SURFACE DEFECTS SUCH AS SCRATCHES, NICKS, OR
DENTS. DEFECTS UP TO 0.005" MAY BE BLENDED OUT LONGITUDINALLY. CIRCUMFERENTIAL GRIND
MARKS ARE UNACCEPTABLE.
- 15) TORQUE CLAMPS 80 TO 100 IN-LB. ENSURE AT LEAST 1.5 THREADS SHOWING IN SAFETY AND THAT NUT
HAS NOT BOTTOMED-OUT AFTER TORQUING.

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 67867

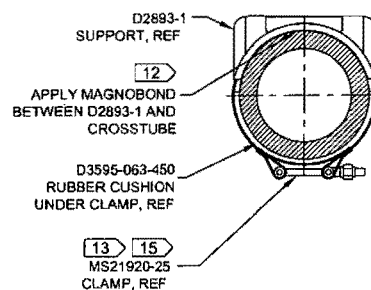
CZ1104/01

RELEASED
2009-10-29
M

D	REFORMAT/REVISE GENERAL NOTES/PART LIST; REORGANIZED VIEWS AND REFORMATTED DRAWING TO CURRENT STANDARDS; ADD -141B (ZN B4-2, D4-2); REMOVED REF & ADD TOLERANCES (ZN B4-3, C6-3, C8-3 & B6-3); RELOCATED FLAG #6 PER PAR 08-046 (ZN A5-3); MOVED TURNING DETAIL & UPDATED TOLERANCE TO SHEET 4	RF	09.09.30
C	REMOVE -851 ABRASION STRIP; ADD MAGNOBOND 6398, CUSHION, REVERSE CLAMPS	PH	07.03.08
B	ADD HOLES FOR COMPATABILITY WITH BHT/AA SKIDTUBES	PH	05.02.04
A	NEW ISSUE	PH	06.12.12
REV.	DESCRIPTION	BY	DATE
DESIGN	PH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	PH	DRAWING NO.	REV. D
MFG. APPR.	PH	D212-664-141	SHEET 1 OF 4
APPROVED	PH	TITLE	SCALE
DE APPR.	PH	XTUBE ASSY (205/212/412 HI FWD)	NTS
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D212-664-141/-141B
ASSEMBLY DETAIL

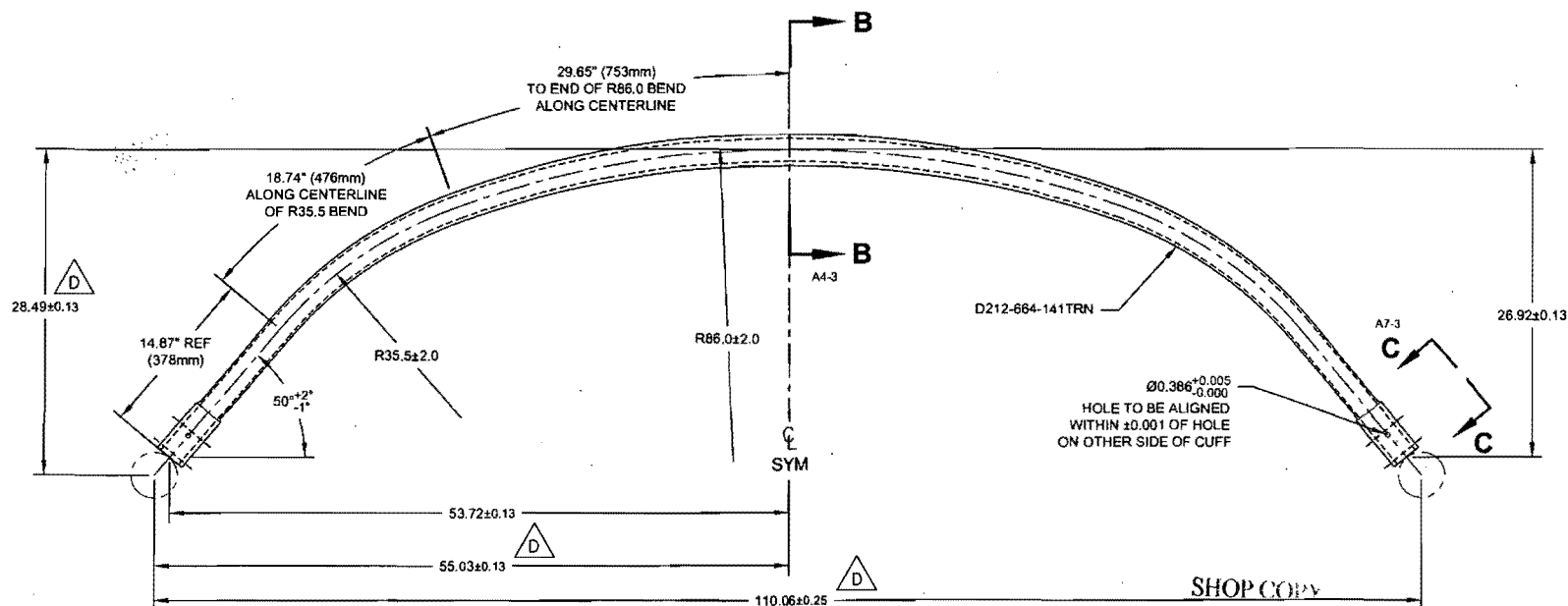


SECTION A-A D5-2
SCALE 4X

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MFG. APPR.	NS	D212-664-141	SHEET 2 OF 4
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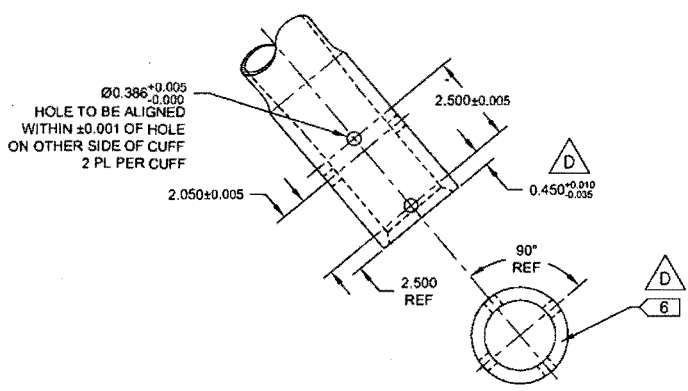


D212-664-501
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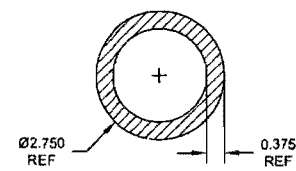


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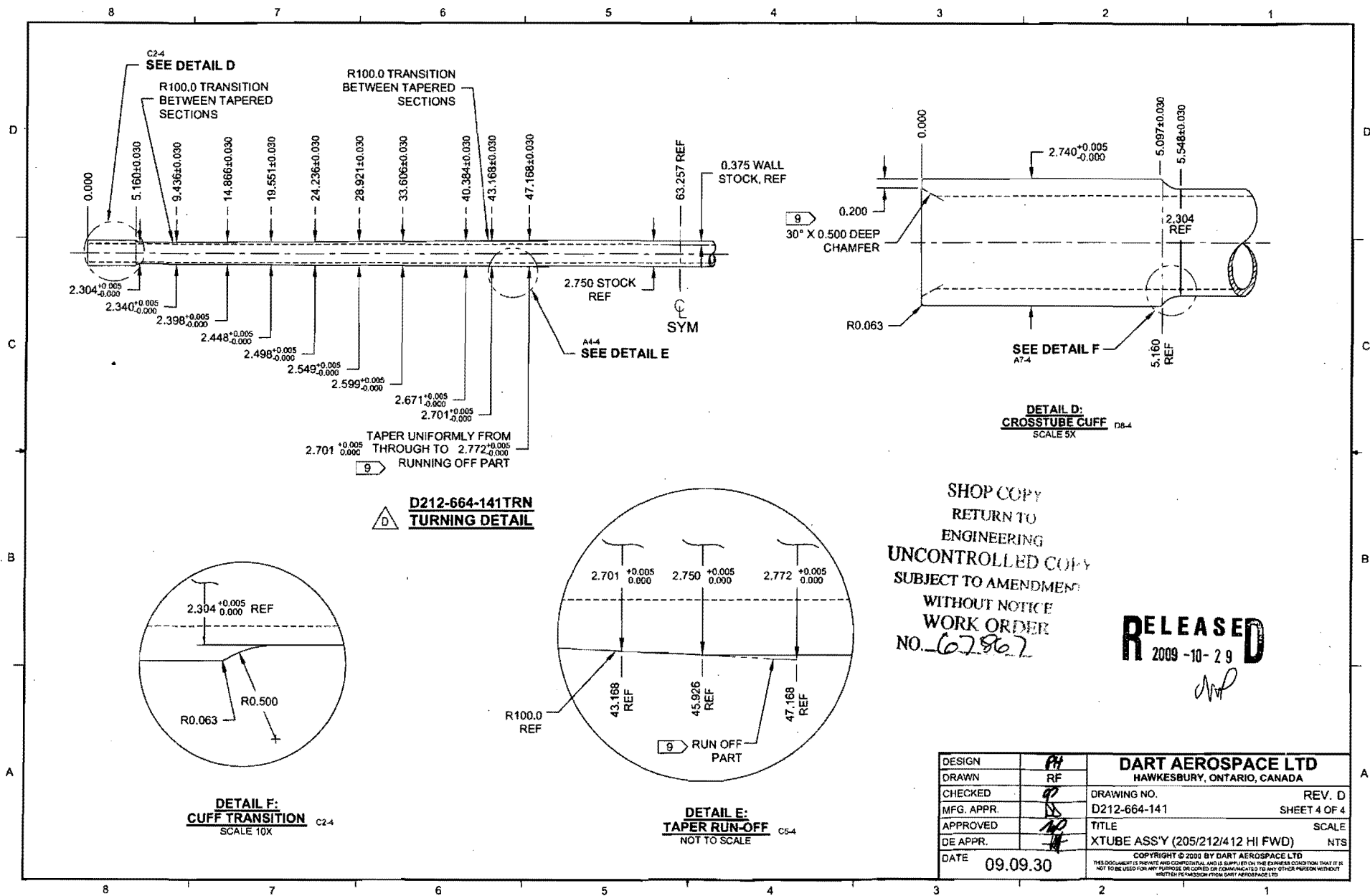


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SECTION B-B
 SCALE 4X

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MFG. APPR.	JS	D212-664-141	SHEET 3 OF 4
APPROVED	JP	TITLE	SCALE
DE APPR.	JP	XTUBE ASSY (205/212/412 HI FWD)	NTS
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HeathAir

INTERNATIONAL (1991) INC.

681 Ave. Lepine, Dorval, Québec H9P 1G3
Tél.: 514 636-1000 • Fax: 514 636-0031

W.O. 44191

A.M.O. Number: 46/90

NON-DESTRUCTIVE TESTING REPORT

AIRCRAFT / COMPONENT INFORMATION

REGISTRATION:

MODEL/TYPE:

SERIAL NUMBER:

TOTAL HR/LDG:

OPERATED BY:

BASED AT:

INSPECTION REQUIREMENTS

Carry out FPI of (4) cross tubes (external surface) as per ASTM E-1417-05 and the Dart QSI 038, Section 4.1.1 (on file at client) - parts delivered to HeathAir.

Qty (2) P/N D212-664-101 S/N's B67866 and B67867.

Qty (1) P/N D206-667-207BL S/N B68089.

Qty (1) P/N D206-667-107BL S/N B68088.

Sales Order Ref.: 230626

Contact: Chantal Lavoie at 613-632-5200 for pick-up.

85 11-04-14

☐ RADIOGRAPHY

☐ ULTRASONIC

☒ PENETRANT

☐ MAGNETIC PARTICLE

☐ EDDY CURRENT

INSPECTION REPORT

Fluorescent penetrant inspection was performed in accordance with the above requirements on (4) cross tubes.

Note: A Level 3 penetrant was substituted for the requested Level 2 (3 is more sensitive)
Ardrox 970P25E Batch #04B503.

(4) cross tubes inspected. (4) PASSED / (0) FAILED.

THE MAINTENANCE DESCRIBED ABOVE HAS BEEN PERFORMED IN ACCORDANCE WITH
THE APPLICABLE STANDARDS OF AIRWORTHINESS

DATE April 13, 2011

INSPECTED BY:

[Signature]
D2 11-04-14

CUSTOMER INFORMATION

CUSTOMER: Dart Aerospace

P.O. NUMBER

P0 13857

ADDRESS:

CONTACT NAME:

Chantal

LABOUR

@

\$

MATERIALS

@

TRAVEL EXPENSES

@

GST

HOTEL EXPENSES

@

PST

INVOICE NO.

P0 13857

TOTAL \$

WHITE COPY - INSPECTION FILE • YELLOW COPY - CUSTOMER • PINK COPY - ACCOUNTANT

DART SERVICE INSTRUCTION

TO AMEND INSTALLATION INSTRUCTIONS IIN-D212-664 Rev. F AND
INSTRUCTIONS FOR CONTINUOUS AIRWORTHINESS ICA-D212-664 Rev. 6

REF. CANADIAN STC: SH01-9

REF. FAA STC: SR01298NY

REF. EASA STC: EASA.IM.R.S.01304

For D212-664-101/-201 High Fwd/Aft Crosstube at CHG 004 or later, and D412-664-203 Aft Crosstubes at CHG 007 or later, an inspection window has been added on the underside of the crosstube to facilitate inspection.

IMPORTANT NOTE: If a D212-664-101/-201 or D412-664-203 Crosstube was stripped of paint, it should now be refinished as follows:

- 1) Apply chemical conversion film material (Alodine 1200 or 1201) per MIL-C-5541 and one coat of MIL-P-85582 or MIL-P-23377 primer.
- 2) Mask underside of crosstube as per hatched area shown in Figures 1 and 2 as applicable.
- 3) Paint outside surfaces of crosstube by applying 2-3 coats of MIL-C-85285 polyurethane paint to match original finish.
- 4) Apply clear coat on inspection window (hatched area).

Additionally, on D412-664-203 Aft Crosstubes at CHG 007 or later, the D2856-600-1009 Abrasion Strips have been removed, and D3189-1 Chafing Shields have been bonded onto the crosstubes using Proseal 890. For D412-664-203 Aft Crosstubes at CHG 007 or later, amend Parts List of IIN-D212-664 Section 5.1 and ICA-D212-664 Section 32.11.1 as follows:

Remove:

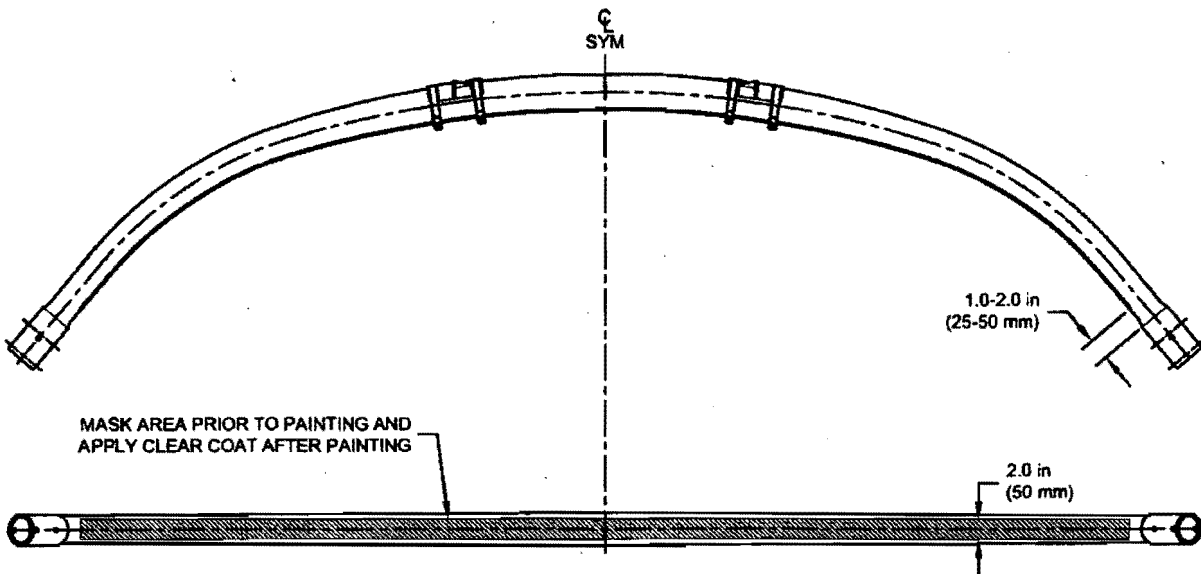
Item	QTY -203	Part Number	Description
31	2	* D2856-600-1009	ABRASION STRIP

If a D3189-1 Chafing Shield is being re-installed on the crosstube, it should now be re-installed as follows:

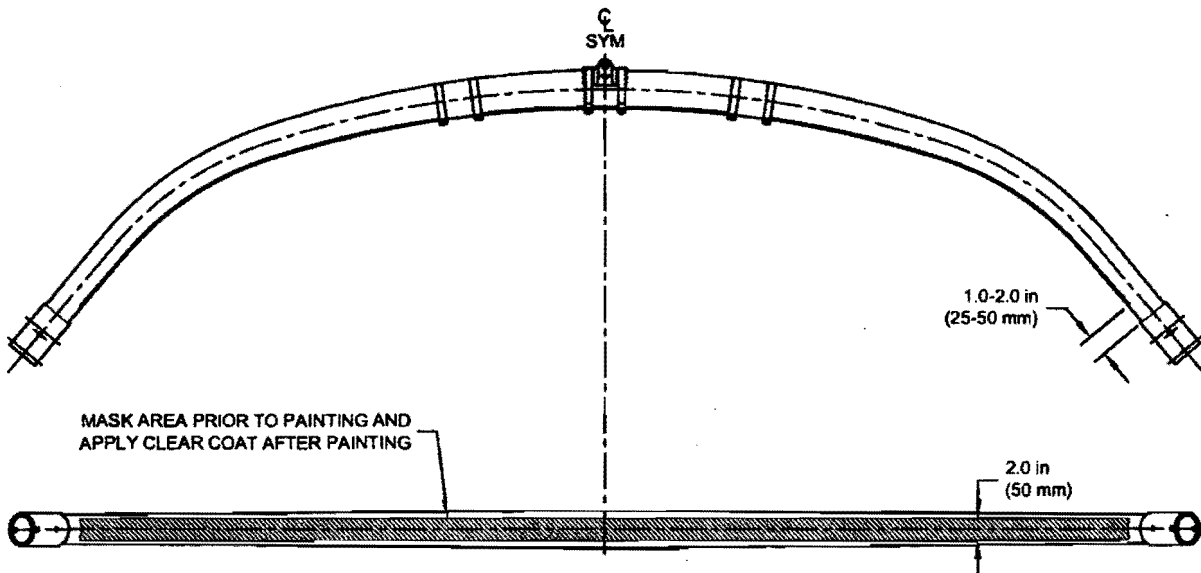
- 1) Follow section 32.1 of ICA-D212-664 for the removal of the crosstubes from the helicopter.
- 2) Remove the qty(2) MS21920-28 Clamps from the crosstube that fasten the D3189-1 Chafing Shields to the crosstube (ref. section 32.5 of ICA-D212-664).
- 3) Remove the D2856-600-1009 Abrasion Strip from the crosstube per section 32.7 of ICA-D212-664.
- 4) Inspect the crosstube surface where the chafing shields and abrasion strips were installed for corrosion and mechanical damage per items 5.3.1 and 5.3.2 of the 300 hour inspection. Repair damage within acceptable limits per item 5.3.3 of the 300 hour inspection. Touch up finish per item 5.3.9 of 300 hour inspection. If crosstube was stripped of paint, refer to instructions below for suitable refinishing of crosstube.
- 5) Apply a 0.02" to 0.04" (0.5-1.0 mm) thick layer of Proseal 890 on the concave surface of D3189-1 Chafing Shields and let cure per manufacturer's instructions.
- 6) Once the Proseal on the D3189-1 Chafing Shields is cured, apply a thin layer of Proseal 890 on the crosstube to cover the area where the Chafing Shields will be installed.
- 7) Locate the D3189-1 Chafing Shield as shown in Figure 3. Ensure that the overlapping edge of the chafing shield is located at approximately 60° from bottom vertical to prevent deterioration of the rubber bumpers. Be sure to eliminate any air gaps.
- 8) Position and tighten the clamps to a torque of 80-100 in-lb (9.0-11.3 N-m).
- 9) Allow the assembly to cure for 12 hours.
- 10) Re-install the D412-664-203 crosstube per section 32.2 of ICA-D212-664.

CANADA DEPARTMENT OF TRANSPORT AIRCRAFT CERTIFICATION BRANCH DAO # 01-O-01	
APPROVED 	
BY:	D. SHEPHERD (DE # 02)
DATE:	11.04.01
CERT. NO.:	SH01-9
ISSUE NO.:	3

A	NEW ISSUE	MB	11.04.01
REV.	DESCRIPTION	BY	DATE
DESIGN		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN		DRAWING NO.	REV. A
CHECKED		DSI 9549	SHEET 1 OF 3
MFG. APPR.		TITLE	SCALE
APPROVED		D212-664 FINISHING CHANGE	NTS
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DATE	11.04.01		



**FIGURE 1 - INSPECTION WINDOW ON
D212-664-101/-201 CROSSTUBES**



**FIGURE 2 - INSPECTION WINDOW ON
D412-664-203 CROSSTUBES**

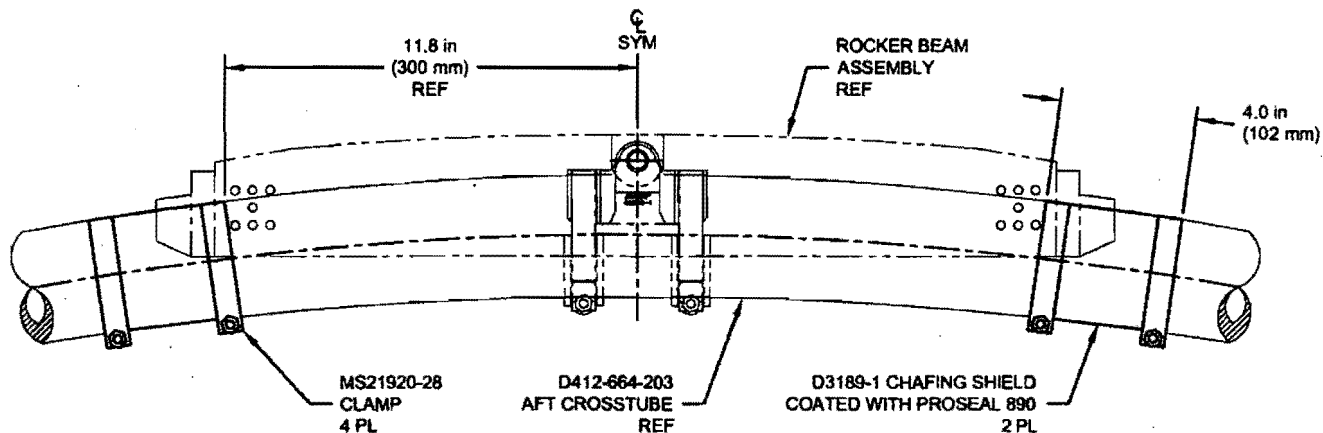
CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01

APPROVED

BY: *[Signature]*
D. SHEPHERD (DE # 02)

DATE: 11.04.01
CERT. NO.: SH01-9
ISSUE NO.: 3

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MFG. APPR.	<i>[Signature]</i>		SHEET 2 OF 3
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**FIGURE 3 - CHAFING SHIELD
INSTALLATION ON D412-664-203**

CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01

APPROVED
BY: *[Signature]*
D. SHEPHERD (DE # 02)

DATE: 11.04.01
CERT. NO.: SH01-9
ISSUE NO.: 3

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MFG. APPR.	<i>[Signature]</i>	DSI 9549	SHEET 3 OF 3
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DE APPR.	<i>[Signature]</i>	D212-664 FINISHING CHANGE	NTS
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DRAWING NO. D212-664-141	TITLE XTUBE ASSY (205/212/412 HI FWD)	REV. D	DART AEROSPACE LTD ENGINEERING ORDER		D.E.O. NO. D212-664-141-D-1	SHEET NO. SHEET 1 OF 2	SCALE NTS
DRAWN		CHECKED	MFG. APPR.	APPROVED	DE APPR.		
DATE 11.04.07		DATE	DATE	DATE	DATE		

PURPOSE:

ADD AN INSPECTION WINDOW TO UNDERSIDE OF CROSSTUBE.

CHANGE:

NOTES 2 OF SHEET 1 IS AMENDED AS FOLLOWS:

IS:

- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
PRIME INSIDE AND OUTSIDE PER DART QSI 005 4.2
MASK UNDERSIDE OF CROSSTUBE AS SHOWN (HATCHED AREA) AND
PAINT OUTSIDE PER DART QSI 005 4.2
REMOVE MASKING AND APPLY CLEAR COAT

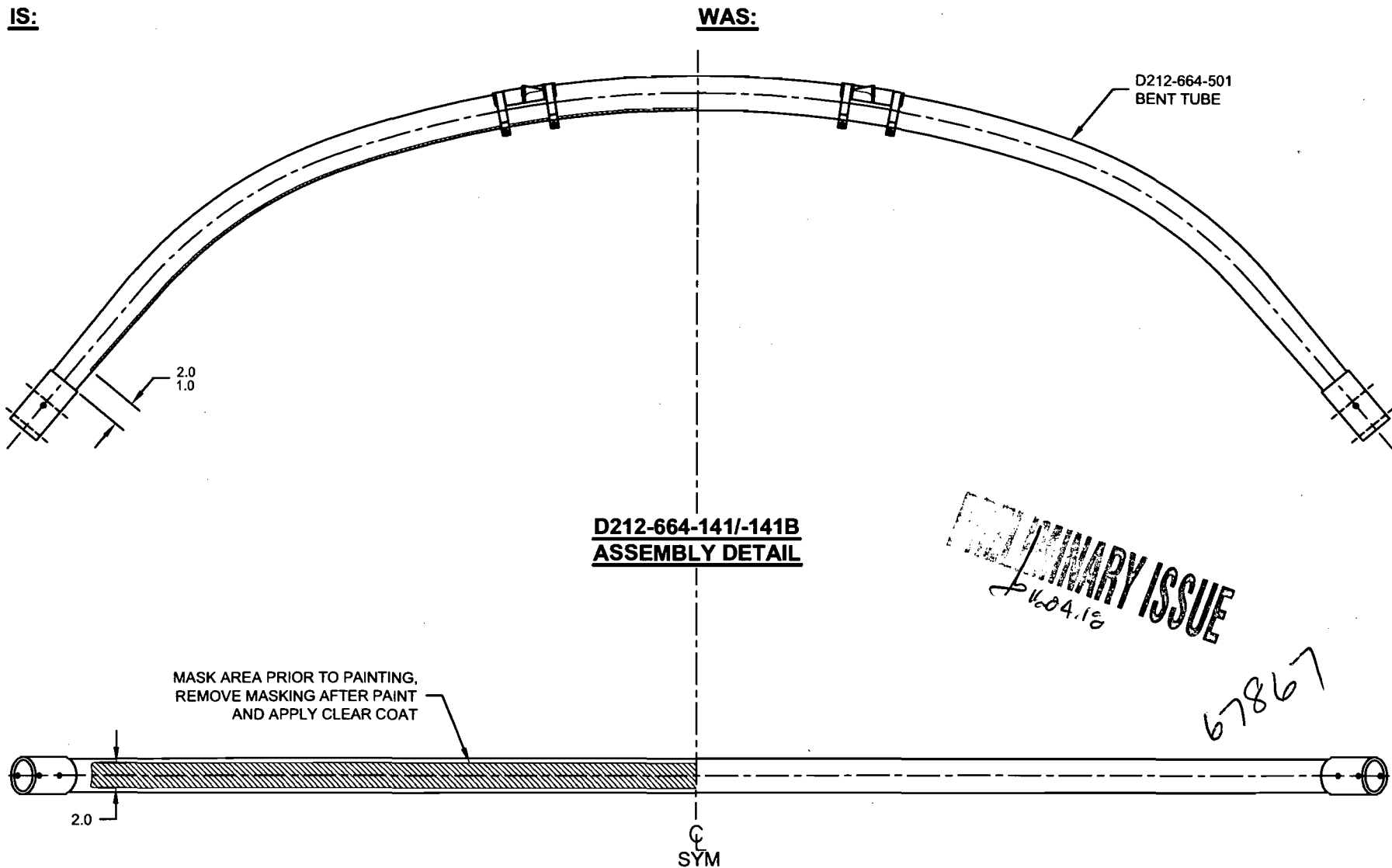
WAS:

- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
PRIME INSIDE AND OUTSIDE PER DART QSI 005 4.2
PAINT OUTSIDE PER DART QSI 005 4.2

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PRELIMINARY ISSUE
11.04.16

DRAWING NO. D212-664-141	TITLE XTUBE ASSY (205/212/412 HI FWD)	REV. D	DART AEROSPACE LTD ENGINEERING ORDER	D.E.O. NO. D212-664-141-D-1	SHEET NO. SHEET 2 OF 2	SCALE NTS
DRAWN		CHECKED	MFG. APPR.	APPROVED	DE APPR.	
DATE 11.04.07		DATE	DATE	DATE	DATE	



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Item	Qty -141	Qty -141B	Part Number	Description
1	X		D212-664-141	CROSSTUBE ASSEMBLY (205/212/412 HIGH FWD)
2		X	D212-664-141B	CROSSTUBE ASSEMBLY (214 HIGH FWD)
3	1	1	D6005-128	CROSSTUBE
4	2	2	D2893-1	SUPPORT
5	4	4	D3595-063-450	RUBBER CUSHION
6	4	4	MS21920-25	CLAMP (OR MS21920-26)
7	A/R	A/R	MAGNOBOND 6398	ROCKWELL SPECIFICATION RBO-120-023 ADHESIVE (TEXTRON/BELL SPEC. 299-947-100, TYPE II, CLASS 2 ADHESIVE)

GENERAL NOTES:

- MATERIAL: MANUFACTURED FROM D6005-128
FINISHED LENGTH = 126.514±0.020
- FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
PRIME INSIDE AND OUTSIDE PER DART QSI 005 4.2
PAINT OUTSIDE PER DART QSI 005 4.2
- TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- UNITS: INCHES UNLESS OTHERWISE NOTED.
- BREAK SHARP EDGES: 0.005 TO 0.010 MAX.
- IDENTIFICATION: SCRIBE DART PART NUMBER "D212-664-XXX" AND BATCH NUMBER ON INSIDE OF CUFF USING VIBRATING STYLUS
- WEIGHT: D212-664-141 = 33.6 lbs (PER IIN-D212-664)
D212-664-141B = 33.6 lbs (PER IIN-D212-664)
- PART IS SYMMETRIC ABOUT CENTERLINE.
- RUN CUTTER OFF PART. BLEND OUT EDGE LONGITUDINALLY, TRANSITION SHOULD BE SMOOTH.
- BEND PROGRESSIVELY WITH A MINIMUM OF 3 PASSES. MAXIMUM TUBE FLATTENING DUE TO BENDING IS 6% BASED ON O.D.
- LIQUID PENETRANT INSPECT OUTSIDE SURFACE OF CROSSTUBE PER QSI 038.
- INSTALL D2893-1 SUPPORT USING 0.03" TO 0.06" THICK LAYER OF MAGNOBOND 6398 TO THE SURFACE OF D2893-1 THAT WILL BE IN CONTACT WITH THE CROSSTUBE PER QSI 015. LET CURE FOR 12 HOURS AFTER INSTALLATION AND PRIOR TO PACKAGING.
- INSTALL MS21920-25 CLAMPS (OR -26) WITH D3595-063-450 RUBBER CUSHIONS TO SECURE THE D2893-1 SUPPORT ON TOP SIDE OF THE CROSSTUBE. ENSURE CLAMPS ARE OPPOSITE OF CROSSTUBE SUPPORT.
- EXTREME CARE MUST BE TAKEN TO PROTECT THE OUTSIDE SURFACE OF THE TUBE. THE OUTSIDE SURFACE MUST BE SMOOTH AND FREE FROM SURFACE DEFECTS SUCH AS SCRATCHES, NICKS, OR DENTS. DEFECTS UP TO 0.005" MAY BE BLENDED OUT LONGITUDINALLY. CIRCUMFERENTIAL GRIND MARKS ARE UNACCEPTABLE.
- TORQUE CLAMPS 80 TO 100 IN-LB. ENSURE AT LEAST 1.5 THREADS SHOWING IN SAFETY AND THAT NUT HAS NOT BOTTOMED-OUT AFTER TORQUING.

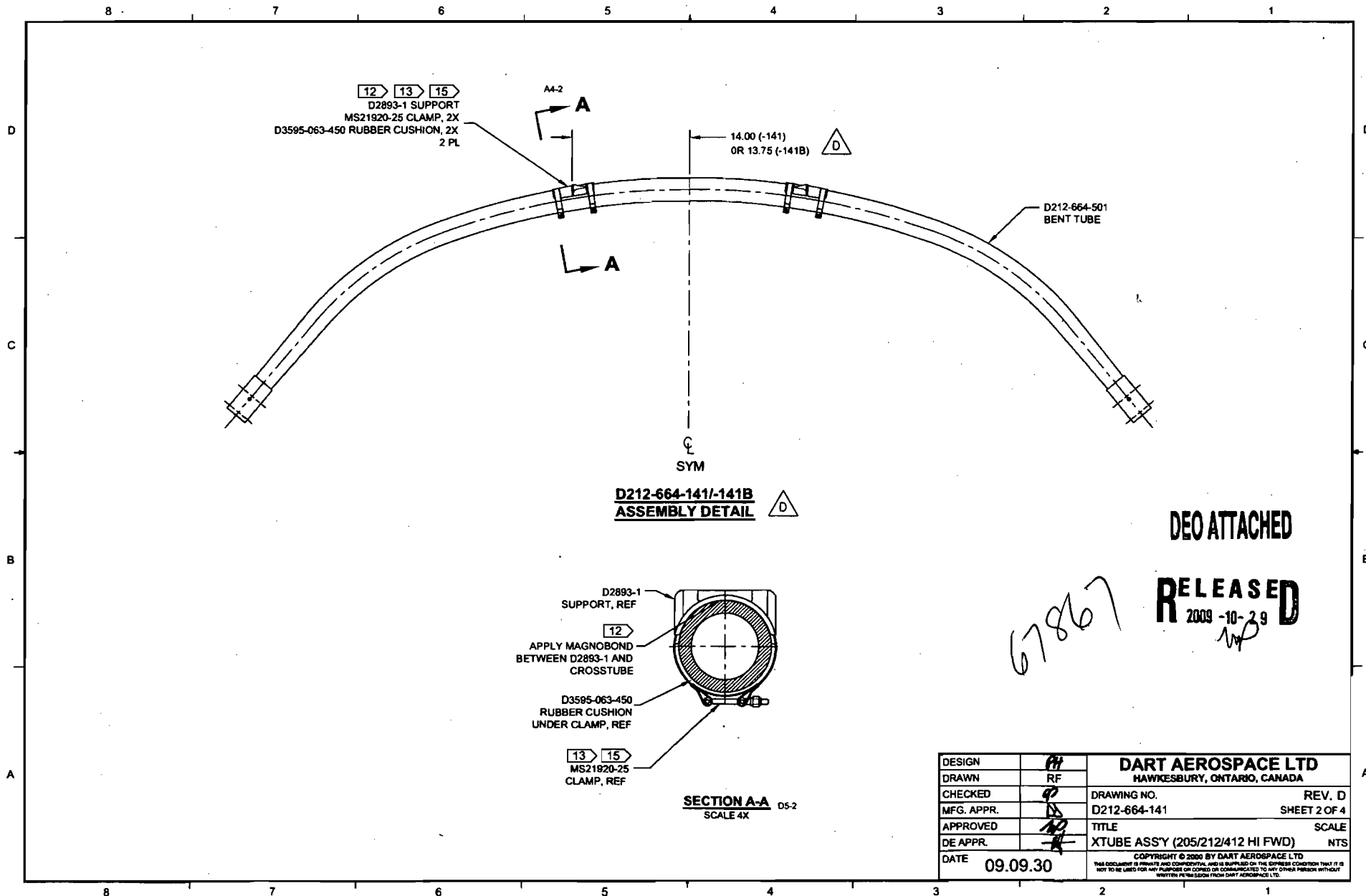
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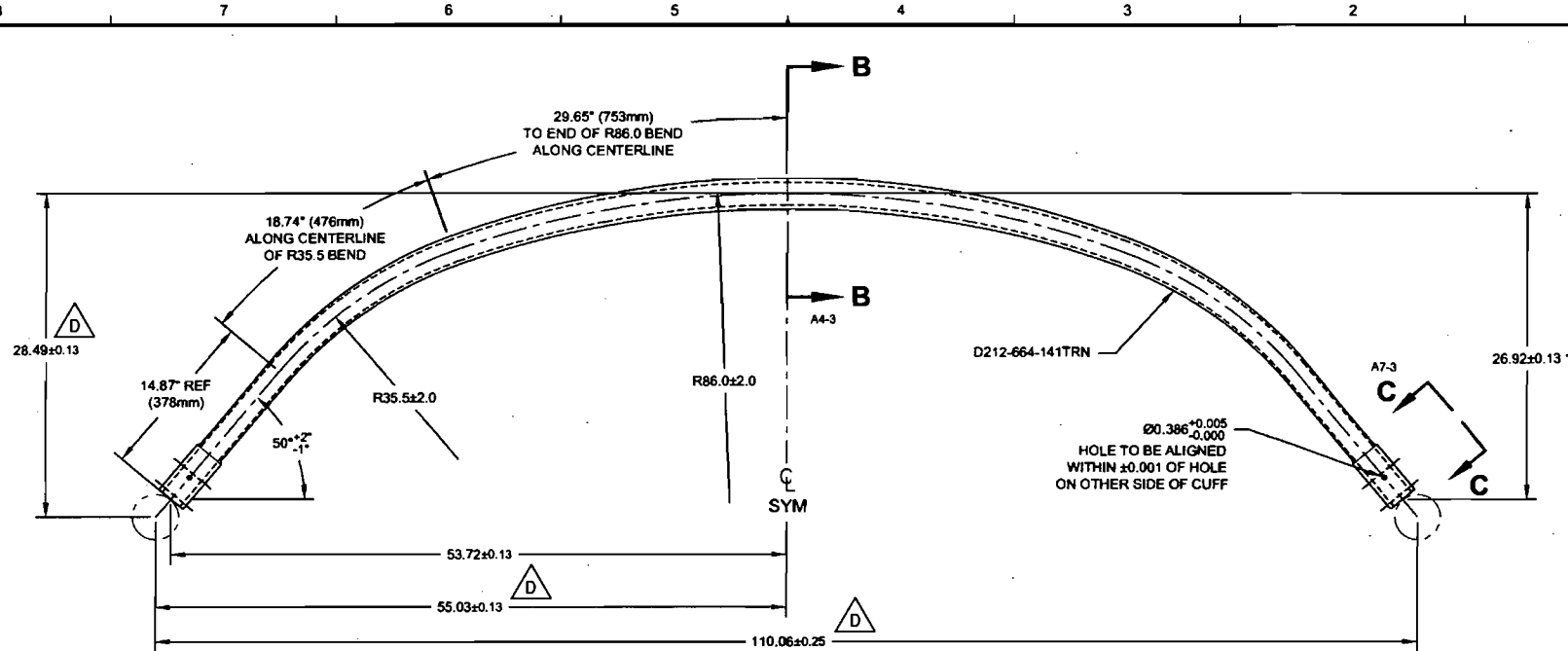
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2009-10-29
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D	REFORMAT/REVISE GENERAL NOTES/PART LIST; REORGANIZED VIEWS AND REFORMATTED DRAWING TO CURRENT STANDARDS; ADD -141B (ZN B4-2, D4-2); REMOVED REF & ADD TOLERANCES (ZN B4-3, C6-3, C8-3 & B6-3); RELOCATED FLAG #6 PER PAR 08-046 (ZN A5-3); MOVED TURNING DETAIL & UPDATED TOLERANCE TO SHEET 4	RF	09.09.30
C	REMOVE -851 ABRASION STRIP; ADD MAGNOBOND 6398, CUSHION, REVERSE CLAMPS	PH	07.03.08
B	ADD HOLES FOR COMPATABILITY WITH BHT/AA SKIDTUBES	PH	05.02.04
A	NEW ISSUE	PH	00.12.12
REV.	DESCRIPTION	BY	DATE
DESIGN	PH	DART AEROSPACE LTD	
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CHECKED	PH	DRAWING NO.	REV. D
MFG. APPR.	PH	D212-664-141	SHEET 1 OF 4
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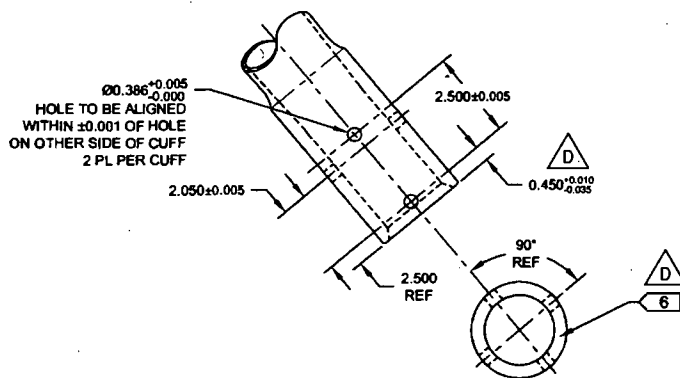
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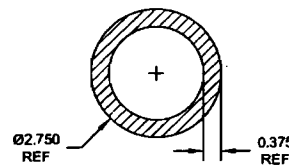
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CHECKED	90	DRAWING NO.	REV. D
MFG. APPR.	10	D212-664-141	SHEET 2 OF 4
APPROVED	10	TITLE	SCALE
DE APPR.	10	XTUBE ASSY (205/212/412 HI FWD)	NTS
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D212-664-501
BENDING AND DRILLING DETAIL 10 D



VIEW C-C: CUFF DETAIL C2-3
 SCALE 3X



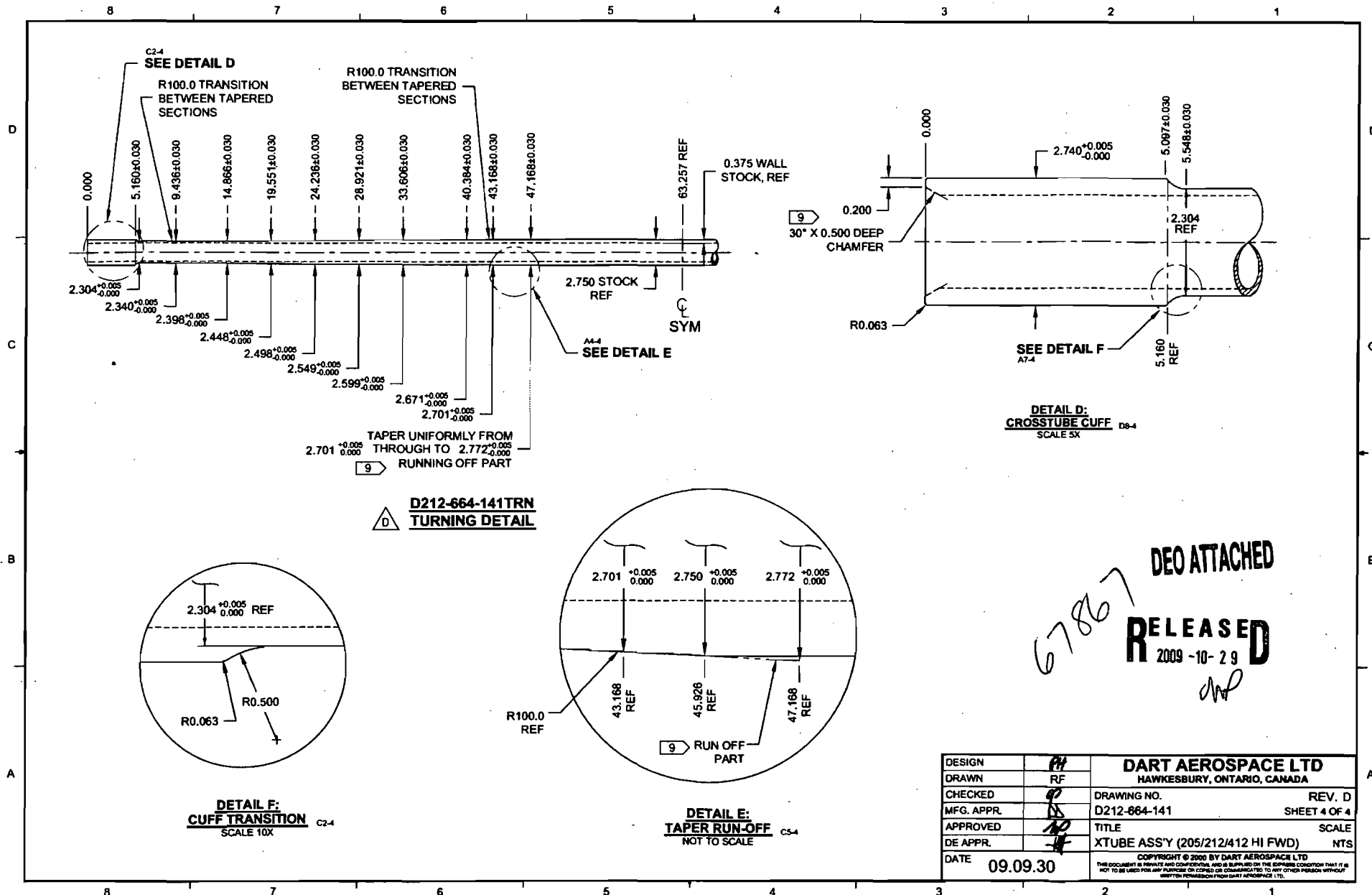
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MFG. APPR.	DS	D212-664-141	SHEET 3 OF 4
APPROVED	AP	TITLE	SCALE
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DRAWN	CHECKED	MFG. APPR.	APPROVED	DE APPR.			
DATE 11.04.07	DATE 11.04.11	DATE 11.04.12	DATE 11/04/12	DATE 11.04.12			

PURPOSE:

ADD AN INSPECTION WINDOW TO UNDERSIDE OF CROSSTUBE.

CHANGE:

NOTES 2 OF SHEET 1 IS AMENDED AS FOLLOWS:

IS:

- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
PRIME INSIDE AND OUTSIDE PER DART QSI 005 4.2
MASK UNDERSIDE OF CROSSTUBE AS SHOWN (HATCHED AREA) AND
PAINT OUTSIDE PER DART QSI 005 4.2
REMOVE MASKING AND APPLY CLEAR COAT

WAS:

- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
PRIME INSIDE AND OUTSIDE PER DART QSI 005 4.2
PAINT OUTSIDE PER DART QSI 005 4.2

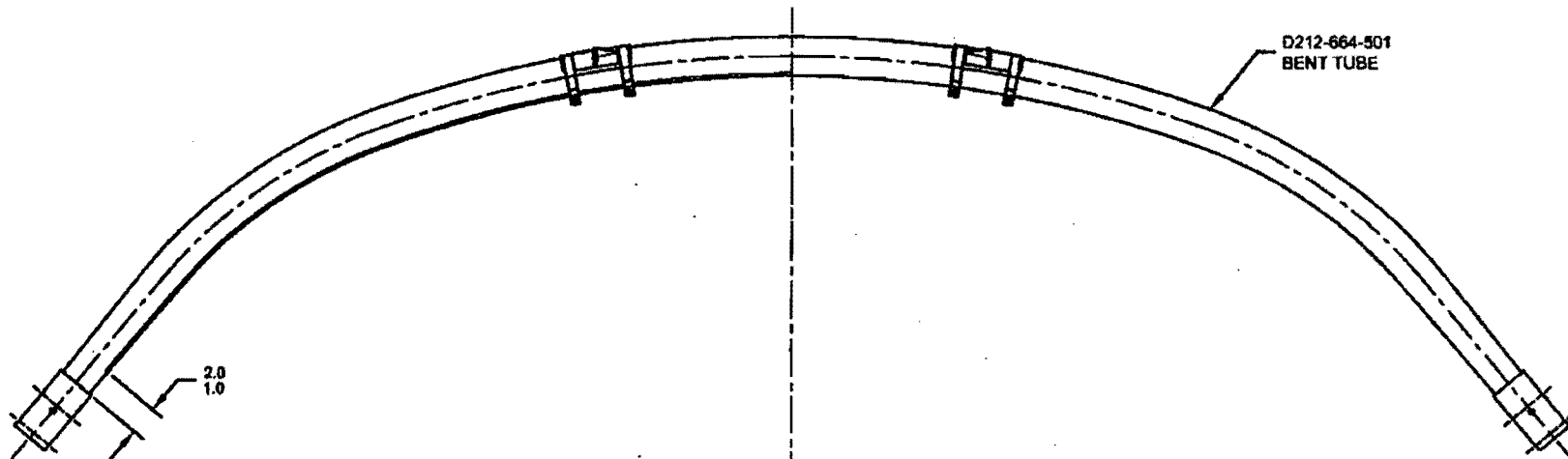
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DRAWN	CHECKED <i>CP</i>	MFG. APPR. <i>CE</i>	APPROVED <i>WMD</i>	DE APPR. <i>WMD</i>		
DATE 11.04.07	DATE 11.04.11	DATE 11.04.12	DATE 11/04/12	DATE 11.04.12		

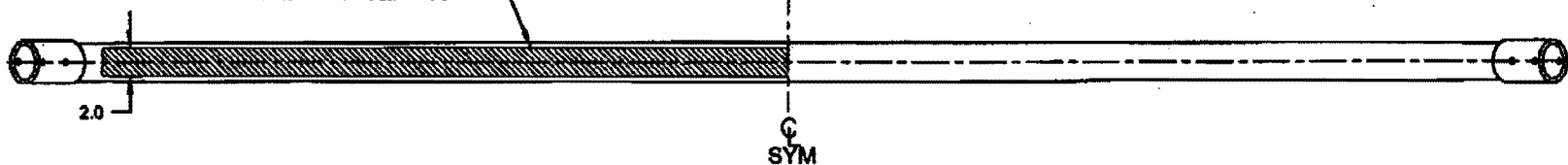
IS:

WAS:



**D212-664-141/-141B
ASSEMBLY DETAIL**

MASK AREA PRIOR TO PAINTING,
REMOVE MASKING AFTER PAINT
AND APPLY CLEAR COAT



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